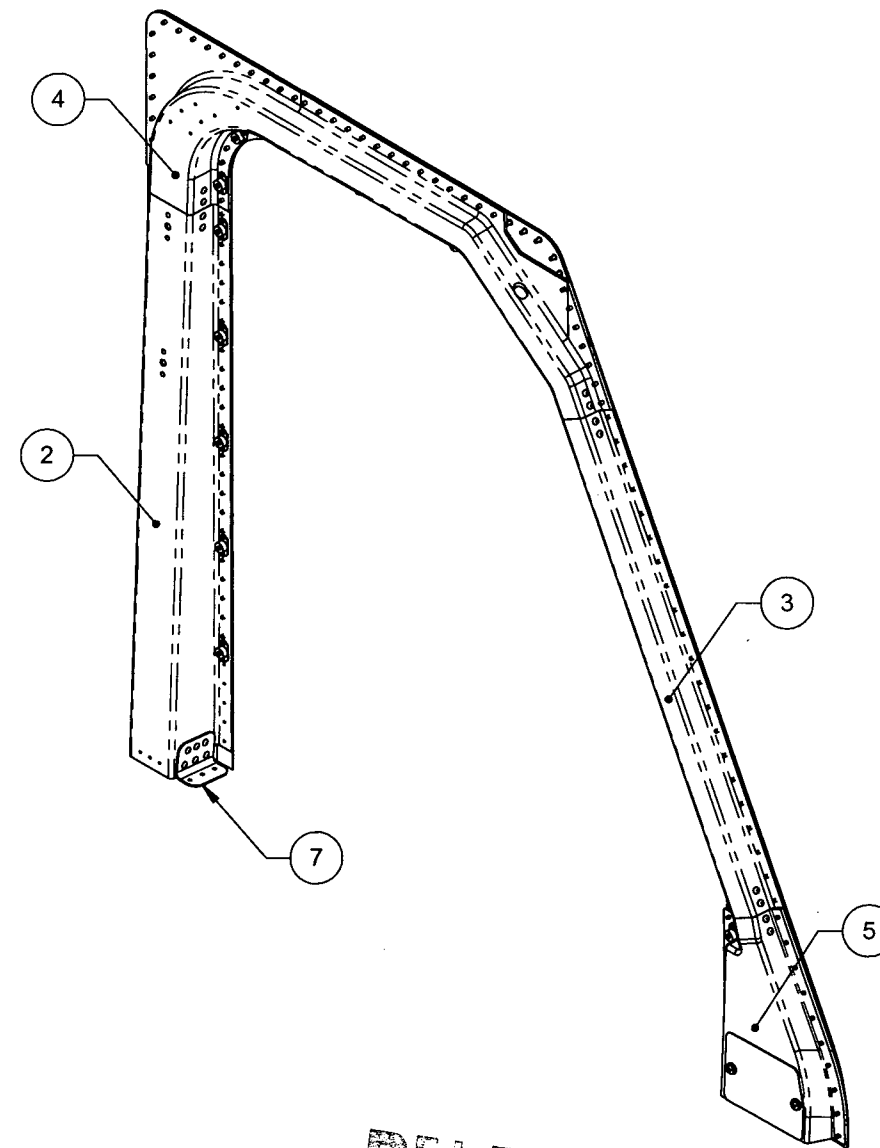
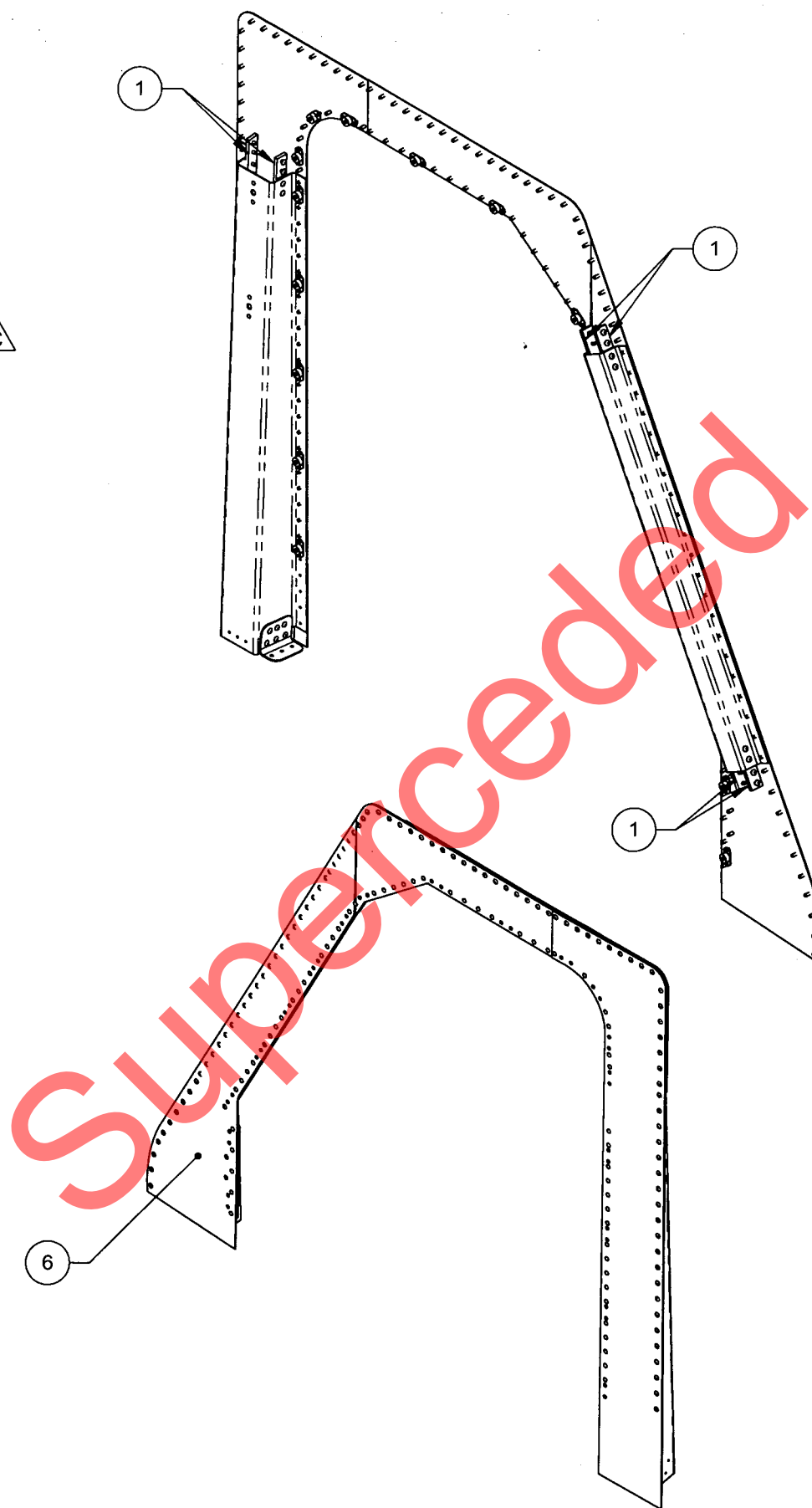


ITEM	QTY -041	P/N	DESCRIPTION
	X	D4466-041	UPPER DOOR ASSY (LH)
1	6	D4474-3	SPLICE BLOCK
2	1	D4496-041	UPPER DOOR CHANNEL ASSY (LH)
3	1	D4499-1	UPPER DOOR CHANNEL (LH)
4	1	D4500-1	BELL DOOR HEADER (LH)
5	1	D4501-041	UPPER DOOR CORNER ASSY (LH)
6	1	D4503-1	UPPER DOOR SKIN
7	1	D4570-3	BRACKET (LH)
8	39	MS20426AD4-3	RIVET, CSK
9	20	MS20426AD3-4	RIVET, CSK
10	16	MS20426AD3-5	RIVET, CSK
11	26	MS20426AD4-5	RIVET, CSK
12	42	MS20470AD4-3	RIVET, PAN HEAD
13	6	MS20470AD4-4	RIVET, PAN HEAD
14	53	MS20470AD4-5	RIVET, PAN HEAD
15	24	MS20470AD4-7	RIVET, PAN HEAD
16	8	MS21059L3	NUTPLATE
17	10	MS21059L3K	NUTPLATE



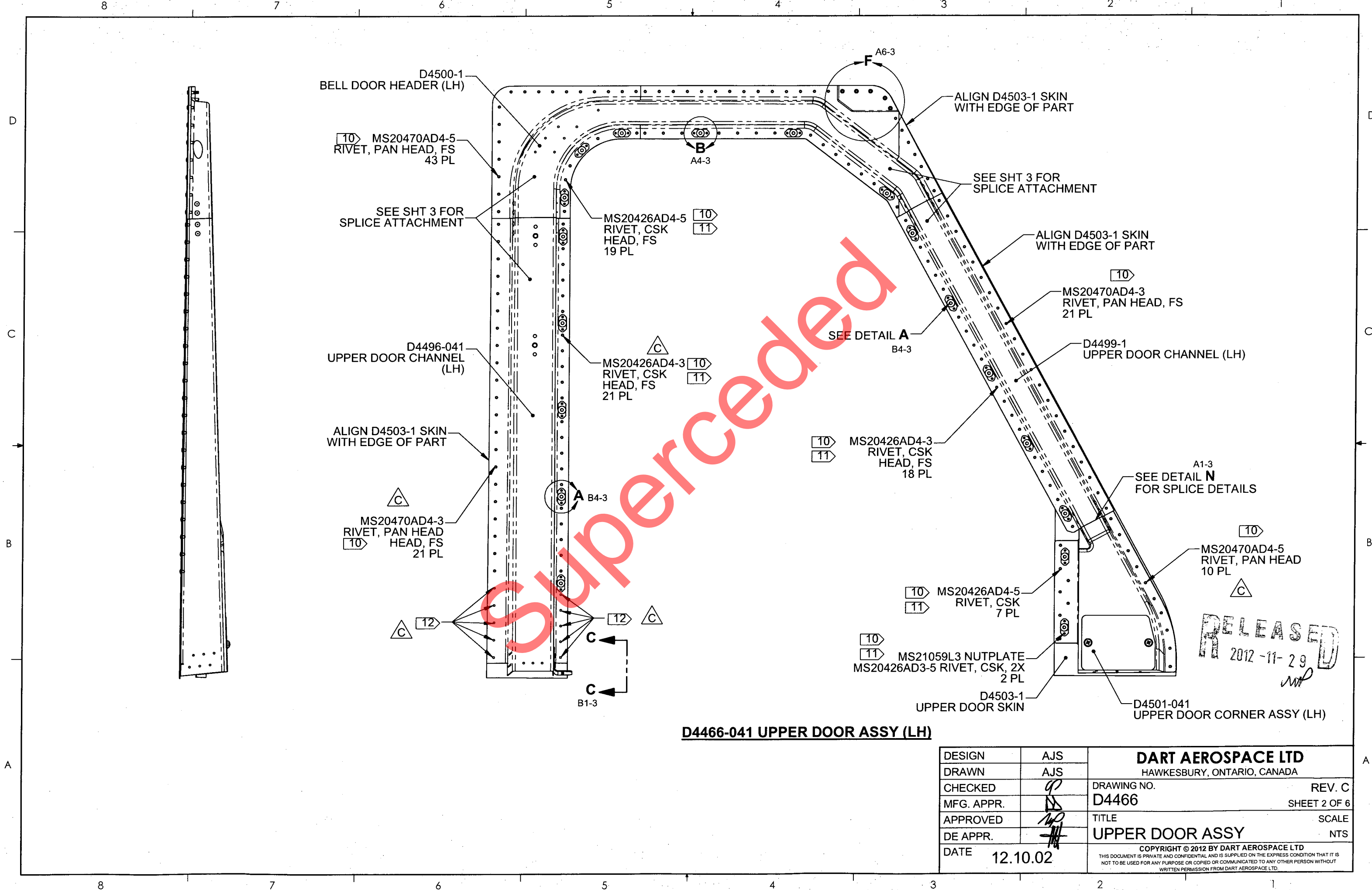
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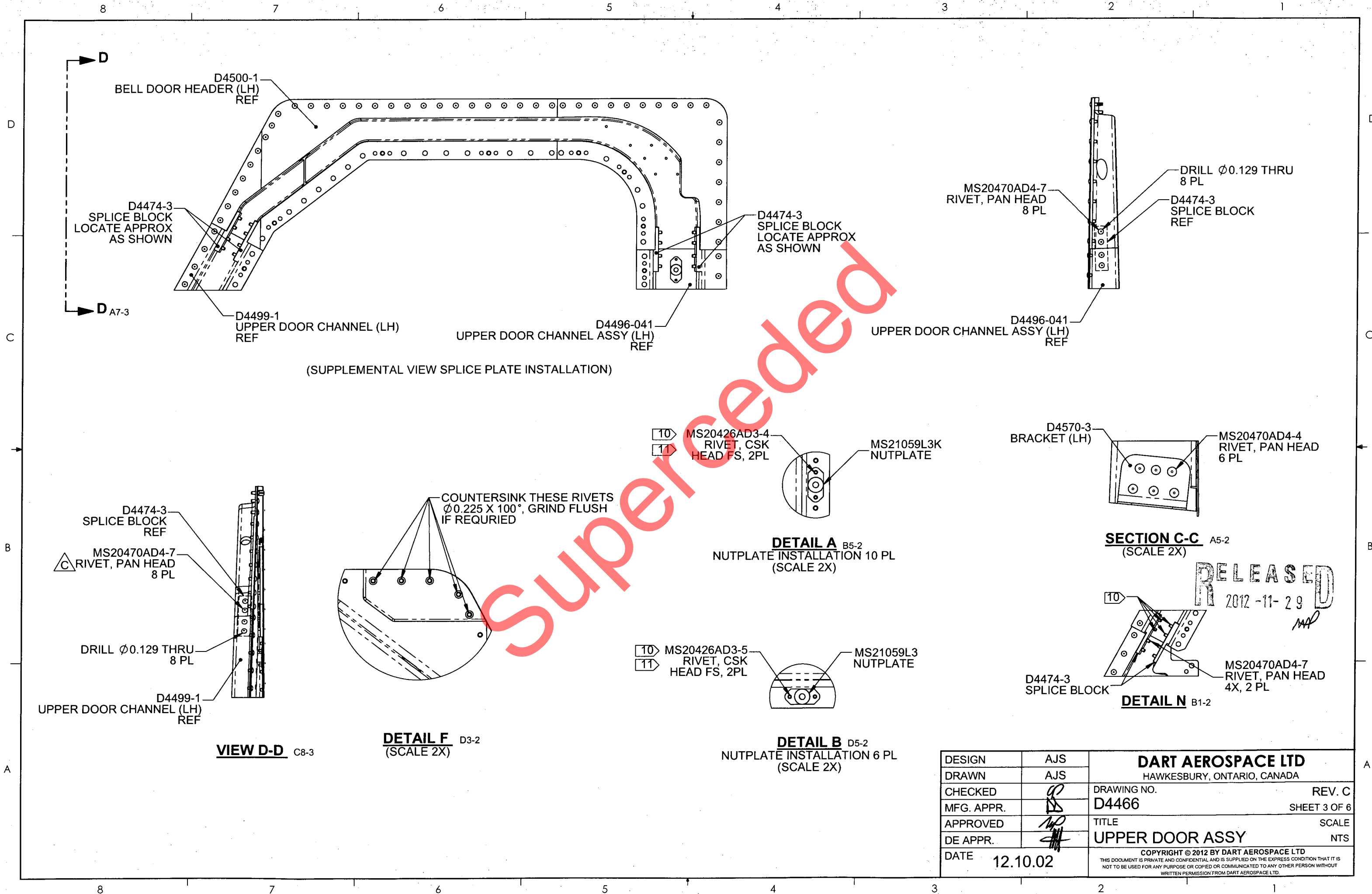
- MATERIAL: N/A
- FINISH: N/A
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: 4.95 lbs
- INSTALL ALL RIVETS WET USING PROSEAL 890 B-2 (PRC)
- SEAL ALL GAPS ON MATING PARTS USING PROSEAL 890 B-2 (PRC)
- ALL RIVET HOLES TO BE TRANSFER DRILLED THRU SKIN (ITEM 6):
FOR $\varnothing 0.125$ RIVETS DRILL $\varnothing 0.129$
FOR $\varnothing 0.094$ RIVETS DRILL $\varnothing 0.098$
- DIMPLE FOR COUNTERSUNK RIVETS:
FOR $\varnothing 0.125$ RIVETS DIMPLE $\varnothing 0.225 \times 100^\circ$
FOR $\varnothing 0.094$ RIVETS DIMPLE $\varnothing 0.179 \times 100^\circ$
- THESE RIVETS OMITTED TO ALLOW ACCESS TO THE UNDERLYING STRUCTURE, INSTALL AT NEXT ASSEMBLY.

D4466-041 UPPER DOOR ASSY (LH)

RELEASED
2012-11-29

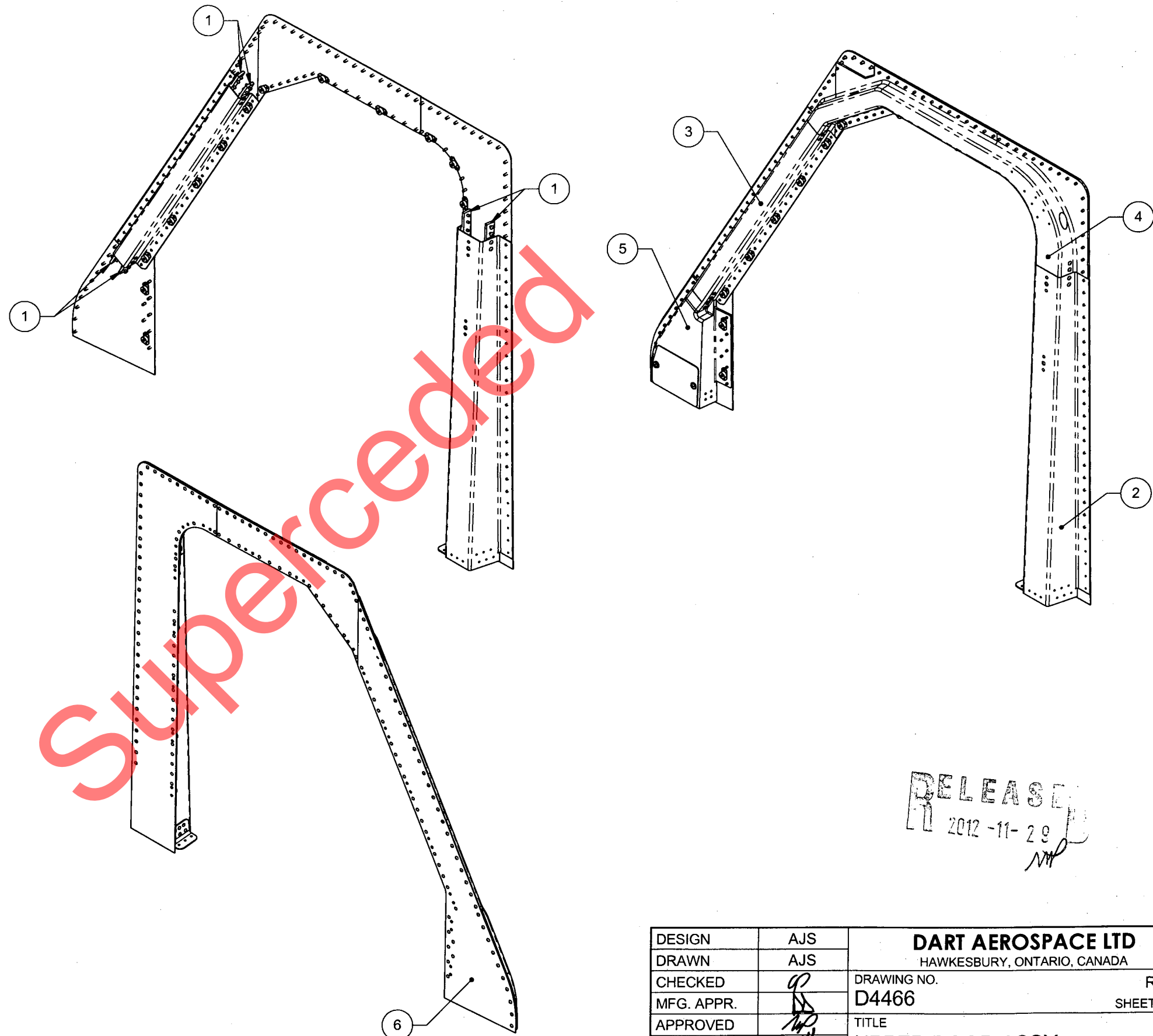
C	ADDED -042 (RH) CONFIGURATION. ADD NOTE 12 UPDATE BOM.	AJS	12.10.02
B	COMPLETE REDESIGN. SEE REV A FOR DETAILS.	AJS	12.09.10
A	NEW ISSUE	AJS	12.02.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	DS	D4466	SHEET 1 OF 6
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	UPPER DOOR ASSY	NTS
DATE	12.10.02	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	





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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4466	SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	UPPER DOOR ASSY	NTS
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ITEM	QTY -042	P/N	DESCRIPTION
	X	D4466-042	UPPER DOOR ASSY (RH)
1	6	D4474-3	SPLICE BLOCK
2	1	D4496-042	UPPER DOOR CHANNEL ASSY (RH)
3	1	D4499-2	UPPER DOOR CHANNEL (RH)
4	1	D4500-2	BELL DOOR HEADER (RH)
5	1	D4501-042	UPPER DOOR CORNER ASSY (RH)
6	1	D4503-1	UPPER DOOR SKIN
7	1	D4570-4	BRACKET (RH)
8	16	MS20426AD3-5	RIVET, CSK
9	20	MS20426AD3-4	RIVET, CSK
10	39	MS20426AD4-3	RIVET, CSK
11	26	MS20426AD4-5	RIVET, CSK
12	42	MS20470AD4-3	RIVET, PAN HEAD
13	6	MS20470AD4-4	RIVET, PAN HEAD
14	53	MS20470AD4-5	RIVET, PAN HEAD
15	24	MS20470AD4-7	RIVET, PAN HEAD
16	8	MS21059L3	NUTPLATE
17	10	MS21059L3K	NUTPLATE



NOTES:

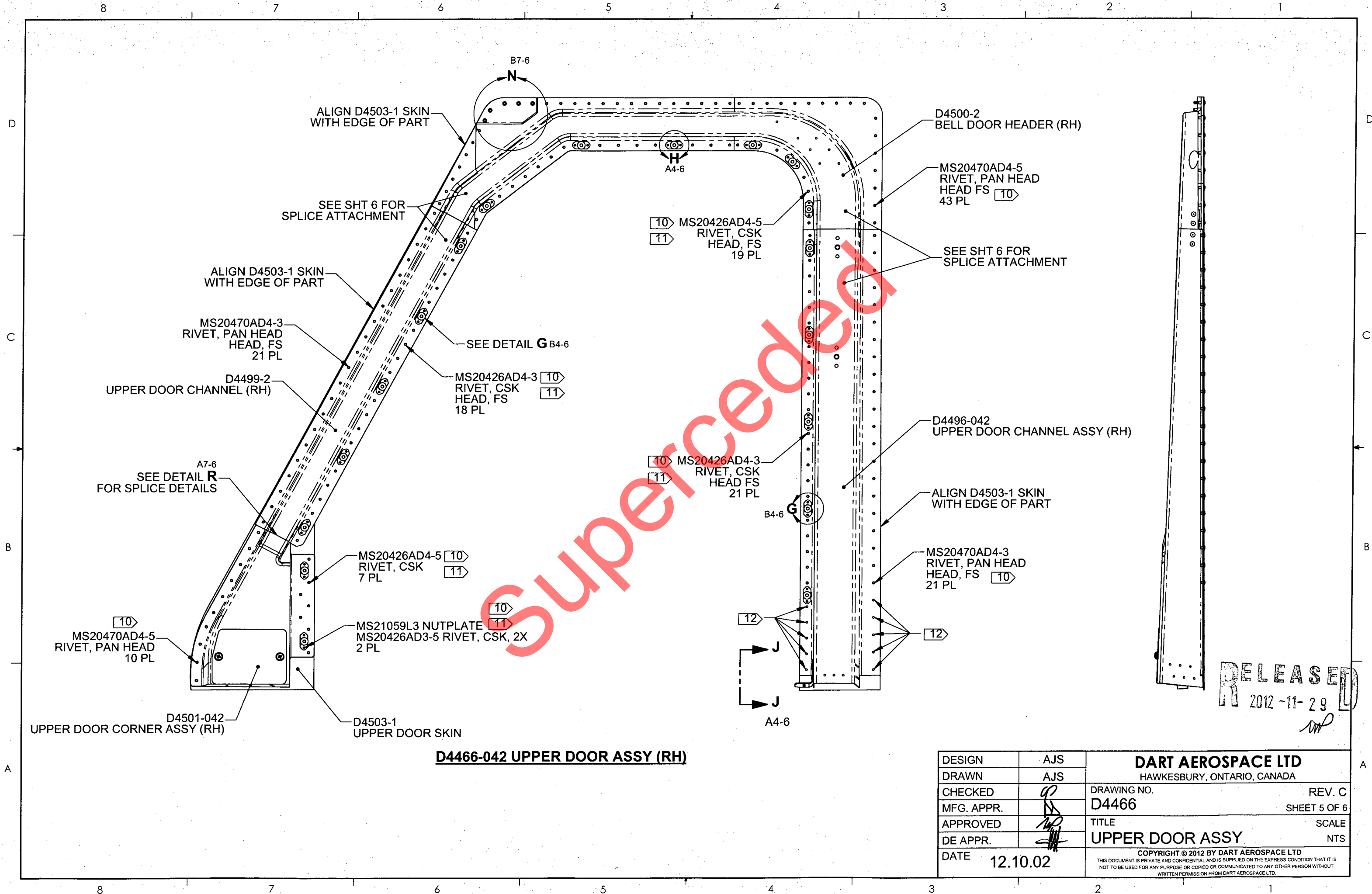
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.73 lbs
- 8) INSTALL ALL RIVETS WET USING PROSEAL 890 B-2 (PRC)
- 9) SEAL ALL GAPS ON MATING PARTS USING PROSEAL 890 B-2 (PRC)
- 10) ALL RIVET HOLES TO BE TRANSFER DRILLED THRU SKIN (ITEM 6):
FOR $\varnothing 0.125$ RIVETS DRILL $\varnothing 0.129$
FOR $\varnothing 0.094$ RIVETS DRILL $\varnothing 0.098$
- 11) DIMPLE FOR COUNTERSUNK RIVETS:
FOR $\varnothing 0.125$ RIVETS DIMPLE $\varnothing 0.225 \times 100^\circ$
FOR $\varnothing 0.094$ RIVETS DIMPLE $\varnothing 0.179 \times 100^\circ$
- 12) THESE RIVETS OMITTED TO ALLOW ACCESS TO THE UNDERLYING STRUCTURE, INSTALL AT NEXT ASSEMBLY.

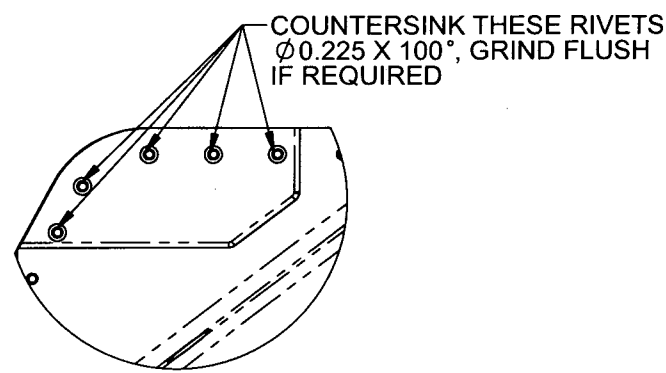
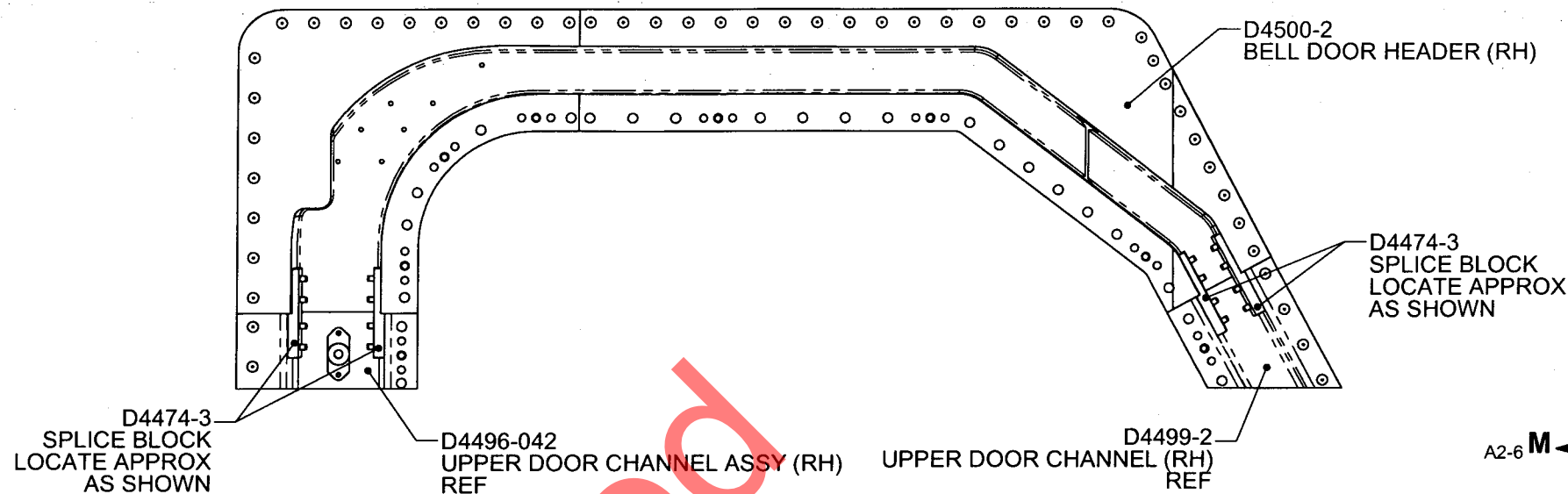
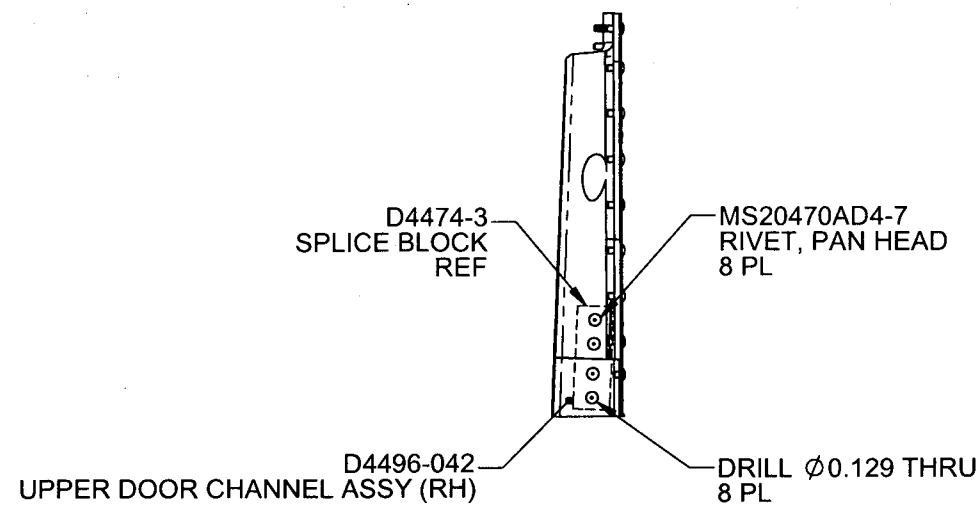


D4466-042 UPPER DOOR ASSY (RH)

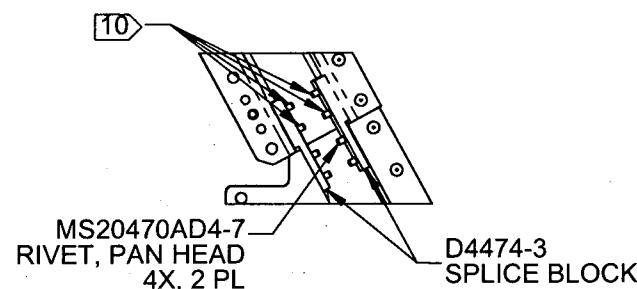
RELEASE
2012-11-29
MP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	GP	DRAWING NO.	REV. C
MFG. APPR.	SS	D4466	SHEET 4 OF 6
APPROVED	MP	TITLE	SCALE
DE APPR.	TH	UPPER DOOR ASSY	NTS
DATE	12.10.02	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

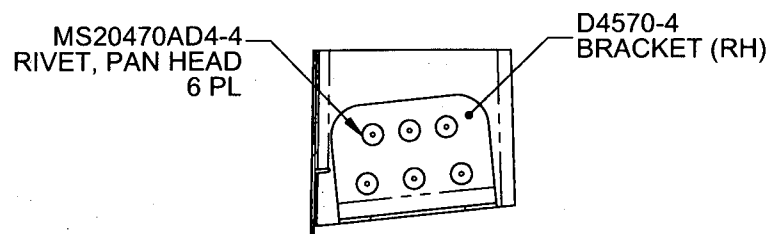
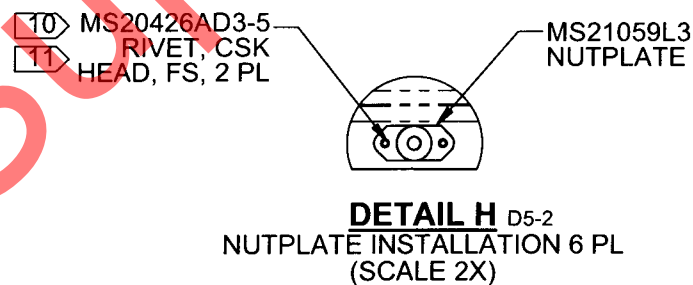
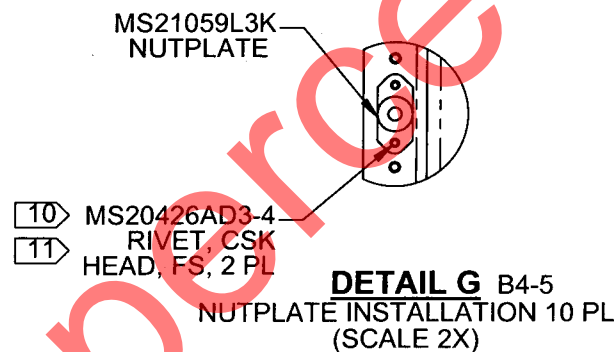




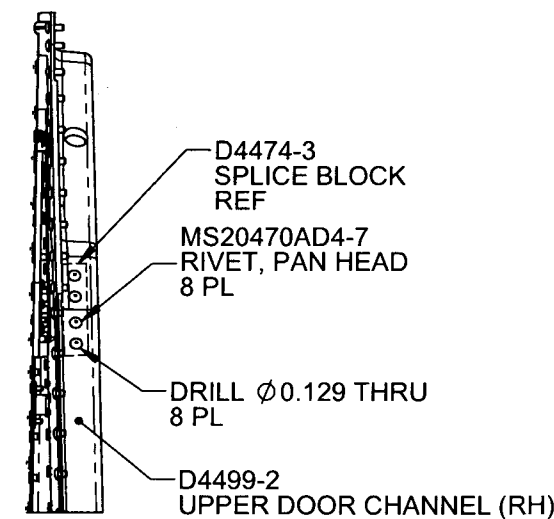
DETAIL N D6-5
(SCALE 2X)



DETAIL R B7-5



SECTION J-J A4-5
(SCALE 2X)



SECTION M-M C1-6

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2012-11-29
MP

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D4466	SHEET 6 OF 6
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DE APPR.	MP	UPPER DOOR ASSY	NTS
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